

• Date: Tuesday, 9/25/2007 10:13:53 AM  
User: Kim Johnston

# Process Sheet

Customer	:	CU-DAR001 Dart Helicopters Services	Drawing Name	:	BEARPAW KIT (13"X24")
Job Number	:	34856			
Estimate Number	:	11540			
P.O. Number	:	N/A	Part Number	:	D206559023
This Issue	:	9/25/2007 S.O. No. : N/A	Drawing Number	:	D2672 REV B1
Prsht Rev.	:	NCI	Project Number	:	N/A
First Issue	:	N/A Type : MACHINED PARTS	Drawing Revision	:	B1
Previous Run	:	25291	Material	:	N/A
Written By	:	<u>[Signature]</u>	Due Date	:	10/10/2007 Qty: 5 Um: Each
Checked & Approved By	:	<u>[Signature]</u>			
Comment	:	Est Rev: E 04.02.17 Tolerance added to Step 3 KJ/JLM			
	:	Est Rev: F 07-01-02 Was K10006 JLM			

### Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1	1000	1000
2	1000	1000
3	1000	1000
4	1000	1000
5	1000	1000
6	1000	1000
7	1000	1000
8	1000	1000
9	1000	1000
10	1000	1000
11	1000	1000
12	1000	1000
13	1000	1000
14	1000	1000
15	1000	1000
16	1000	1000
17	1000	1000
18	1000	1000
19	1000	1000
20	1000	1000
21	1000	1000
22	1000	1000
23	1000	1000
24	1000	1000
25	1000	1000
26	1000	1000
27	1000	1000
28	1000	1000
29	1000	1000
30	1000	1000
31	1000	1000
32	1000	1000
33	1000	1000
34	1000	1000
35	1000	1000
36	1000	1000
37	1000	1000
38	1000	1000
39	1000	1000
40	1000	1000
41	1000	1000
42	1000	1000
43	1000	1000
44	1000	1000
45	1000	1000
46	1000	1000
47	1000	1000
48	1000	1000
49	1000	1000
50	1000	1000
51	1000	1000
52	1000	1000
53	1000	1000
54	1000	1000
55	1000	1000
56	1000	1000
57	1000	1000
58	1000	1000
59	1000	1000
60	1000	1000
61	1000	1000
62	1000	1000
63	1000	1000
64	1000	1000
65	1000	1000
66	1000	1000
67	1000	1000
68	1000	1000
69	1000	1000
70	1000	1000
71	1000	1000
72	1000	1000
73	1000	1000
74	1000	1000
75	1000	1000
76	1000	1000
77	1000	1000
78	1000	1000
79	1000	1000
80	1000	1000
81	1000	1000
82	1000	1000
83	1000	1000
84	1000	1000
85	1000	1000
86	1000	1000
87	1000	1000
88	1000	1000
89	1000	1000
90	1000	1000
91	1000	1000
92	1000	1000
93	1000	1000
94	1000	1000
95	1000	1000
96	1000	1000
97	1000	1000
98	1000	1000
99	1000	1000
100	1000	1000

1.0 DC DOCUMENT CONTROL



**Comment:** DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-559-023 CHG006

5/10/17

2.0	MUHMWB10	UHMW 1" Black
-----	----------	---------------



Comment: Qty: ~~447~~ 2.3427 sf(s)/Unit Total: ~~41.7133~~ sf(s)

blank: 13.250" x 24.25" x 1.00" thick (+0.030/-0.000) per DSK086-2

Material: Black UHMW 1"

(MUHMWB10)

Batch: M103975

inl 07/10/10

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1

Note: (2) bearpaws for (1) Kit

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio and Dwg D2672 Identify as D2672

### 3-Deburr

ml 07/10/11

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

Mr. O. F. H. H.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW KIT (13"X24")

Job Number: 34856

Part Number: D206559023

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SG 67.16.15

(10)

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

7.0

D2182B

Neoprene Cushion-.750 bl



Comment: Qty.: 2.5000 f(s)/Unit Total : 12.5000 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 D2182B050 Rubber Cushion

B30872

SO

8.0

D2274

Radius Block



Comment: Qty.: 12.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 D2274 Radius Block

2 D2672(ref only) Bearpaw

B30875

B32015

SG

9.0

D2438

Clamp



Comment: Qty.: 6.0000 Each(s)/Unit Total : 30.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 D2438 Clamp

33937

SG

10.0

D2529

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 D2529 Washer

B27876

B30382

2/10/15 SG

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 9/25/2007 10:13:53 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW KIT (13"X24")

Job Number: 34856

Part Number: D206559023

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

D2732

Rubber Extrusion



Comment: Qty.: 0.4160 Each(s)/Unit Total : 2.0800 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 D2732-050 Rubber Cushion

334717

12.0

AN415A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 AN4-15A Bolt

M104072

54

13.0

AN417A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 AN4-17A Bolt

M103691

54

14.0

AN960JD416

Washer



Comment: Qty.: 24.0000 Each(s)/Unit Total : 120.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

24 AN960JD416 Washer

M19185

M104746, 50

15.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 MS21042L4 Nut (or -4)

M104683

7/10/15 54 (5X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 9/25/2007 10:13:53 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW KIT (13"X24")

Job Number: 34856

Part Number: D206559023

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

*Er 07/10/17 (5)*

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPPD206-559-023

Location: *DRM*

*07/10/17 (5)*

18.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*07/10/17*

Job Completion



*u 07.10.17*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	34856
<b>Description:</b> Bearpaw		<b>Part Number:</b>	D2672
<b>Inspection Dwg:</b> D2672 <b>Rev:</b> B1		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	23.750	+/-0.030	23.750	—			
B	12.750	+/-0.030	12.750	—			
C	4.250	+/-0.010	4.250	—			
D	2.000	+/-0.030	2.600	—			
E	9.000	+/-0.010	9.000	—			
F	0.375	+/-0.030	0.380	—			
G	9.000	+/-0.010	9.000	—			
H	Ø0.260	+0.005/-0.000	Ø0.260	—			
I	Ø0.93	+/-0.030	Ø0.929	—			
J	0.300	+0.030/-0.000	0.365	—			
K	0.625	+/-0.030	0.600	—			
L	0.063 x 45°	+0.030/-0.010	0.053x45°	—			
M	0.250	+/-0.010	0.253	—			
N	5.500	+/-0.030	5.502	—			
O	R0.250	+/-0.030	R0.250	—			
P	0.200	+/-0.030	0.198	—			
Q	0.25 x 45°	+/-0.030	0.238x45°	—			
R	0.950	+0.030/-0.010	0.945	—			
S	0.375	+/-0.010	0.378	—			

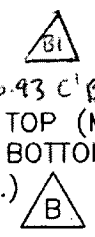
<b>Measured by:</b>	<i>ml</i>	<b>Audited by:</b>	JF	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	07/10/10	<b>Date:</b>	07/10/10	<b>Date:</b>	

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue	KJ/RF <i>[Signature]</i>	<i>[Signature]</i>



DESIGN	KE	DRAWN BY	KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	KE	APPROVED	KE	DRAWING NO. D2672
DATE	98.05.19	TITLE	BEARPAW	REV. B
				SHEET 1 OF 2
				SCALE 1:5
A	97.04.08	NEW ISSUE		
B	98.05.19	CHANGE C'BORE, R1.58 WAS R1.50		
B1	98.06.17	CHANGE C'BORE, R1.58 WAS R1.50		

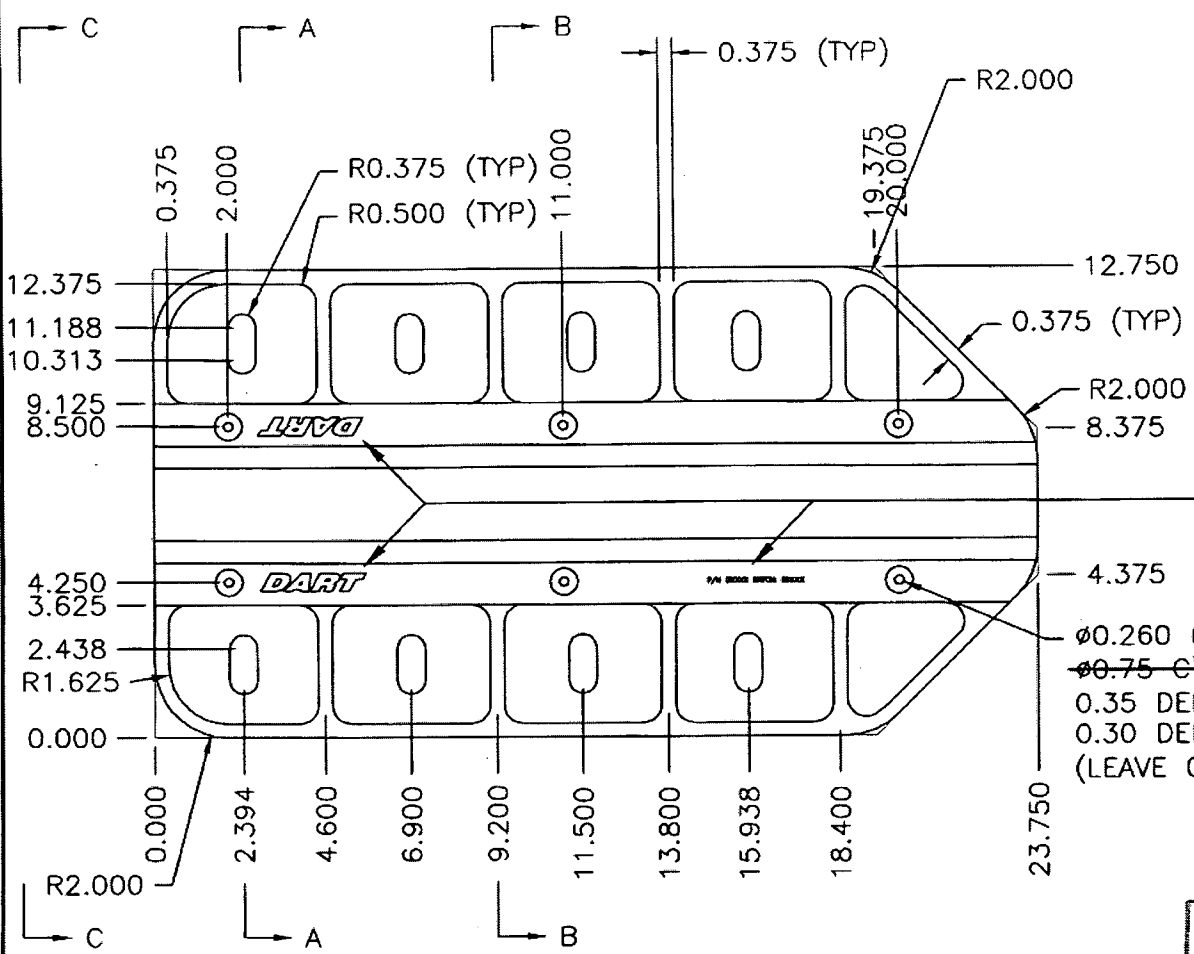
ENGRAVE LOGO TO  
MAX DEPTH OF  
0.012. ENGRAVE  
PART AND BATCH  
NUMBERS TO MAX  
DEPTH OF 0.010.  
(TYPICAL LOCATION  
AS ILLUSTRATED)



$\phi 0.260$  (TYP)  
 ~~$\phi 0.75$  C'BORE~~  $\phi 0.93$  C'BORE  
0.35 DEEP FROM TOP (MIN.)  
0.30 DEEP FROM BOTTOM  
(LEAVE 0.300 MIN.)

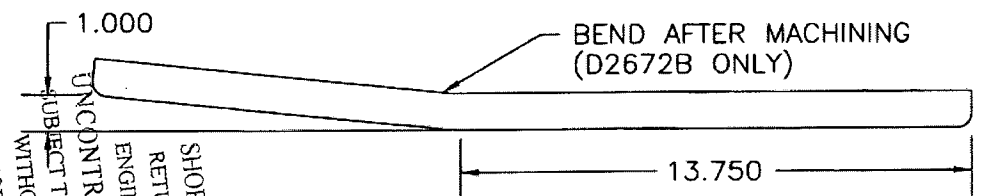
EFFECTIVE	DEOS
9/14/3	

RELEASED  
98.06.17 KE



FLAT PATTERN

D2672F: FLAT BEARPAW  
D2672B: BENT BEARPAW



MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689  
1.00 THICK (MACHINE TO 0.950)

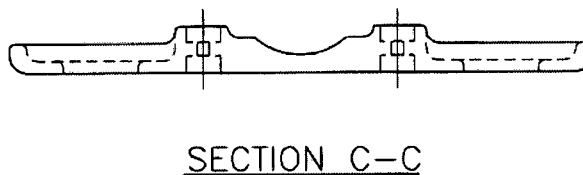
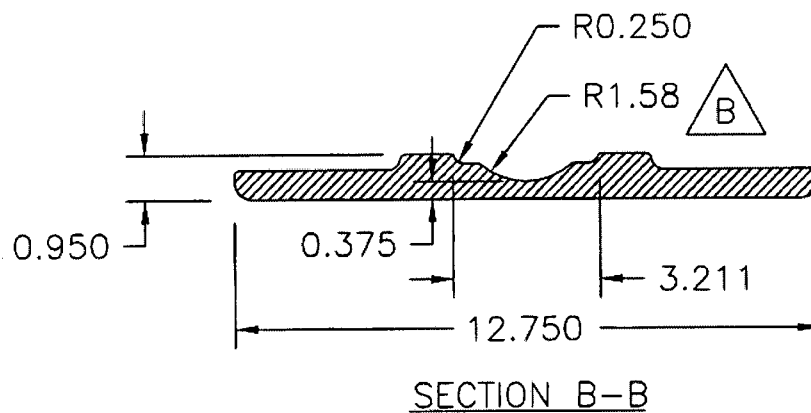
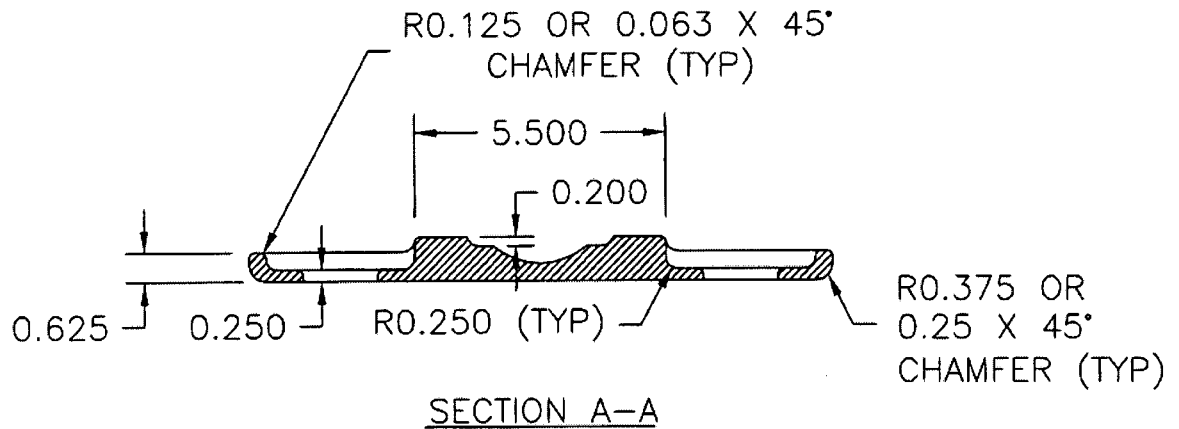
Copyright 1997 by DART AEROSPACE LTD

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 34856



DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2672	REV. B SHEET 2 OF 2
DATE 98.05.19		TITLE BEARPAW	SCALE 1:4

RELEASED  
99.06.17 KE



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 34856

Date: Tuesday, 9/25/2007 10:13:53 AM  
 User: Kim Johnston

## Process Sheet

41

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BEARPAW KIT (13"X24")
Job Number	: 34856		
Estimate Number	: 11540		
P.O. Number	:	Part Number	: D206559023
This Issue	: 9/25/2007 S.O. No. :	Drawing Number	: D2672 REV B1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 11 Type : MACHINED PARTS	Drawing Revision	: B1
Previous Run	: 25291	Material	:
Written By	: <u>07.09.25</u>	Due Date	: 10/10/2007 Qty: 5 Um: Each
Checked & Approved By	: <u>07.09.25</u>		
Comment	: Est Rev: E 04.02.17 Tolerance added to Step 3 KJ/JLM Est Rev: F 07-01-02 Was K10006 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-559-023 CHG006

07.09.25

2.0	MUHMWB10	UHMW 1" Black
-----	----------	---------------



Comment: Qty.: 2.3427 sf(s)/Unit Total : 11.7133 sf(s)  
 blank: 113.250" x 24.25" x 1.00" thick (+0.030/-0.000) per DSK086-2  
 Material: Black UHMW 1"  
 (MUHMWB10)  
 Batch: \_\_\_\_\_

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1

Note: (2) bearpaws for (1) Kit

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio and Dwg D2672 Identify as D2672

3-Deburr

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

REFERENCE ONLY

Customer : CC-DAR01 Dart Aerospace Ltd.  
Job Number : 36674  
Estimate Number : 10804  
P.O. Number : *N/A*  
This Issue : 09/01/2008 S.O. No. : *N/A*  
Prsht Rev. : *NC*  
First Issue : *N/A* Type : MACHINED PARTS  
Previous Run : 00015

Drawing Name : D206-559

Part Number : Z\_CUSTOM  
Drawing Number : ECN1101  
Project Number : *N/A*  
Drawing Revision : *N/A*  
Material : *N/A*  
Due Date : 16/01/2008

Qty: 1 Um: Each

Written By : *[Signature]*  
Checked & Approved By : *[Signature]*  
Comment :

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

REMOVE FROM STOCK:

D206-559-011

*B34284 (10x) B30377 (x2) B30800 (x1) B32977 (x5)*

D206-559-013

*B32728 9x B30340 (2x)*

✓ D206-559-021

*B28342 (x4)*

D206-559-023

*B25291 (x3) B34856 (x5)*

D206-559-025

*B28731 (x4)*

ADD NEW PAPERWORK JCAB STC: STC-90-TYO  
PER ECN 1101

RETURN TO STK

*8/1/10 SD (45x) AS*

2.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*20810/11*

Job Completion



*12 28-0-11*